

# Work Order ID 53682

November 12, 2009 8:51:22 AM

13/14



PRELIMINARY ISSUE

Page 1

Item ID: D4015-041

Accept



Setup Start



Revision ID:

Item Name: Wearbar Weldment

Stop



Start Date: 11/12/09 Start Qty: 5.00



Cust Item ID:

Required Date: 11/13/09 Req'd Qty: 5.00



Customer:

Reference:

Approvals: Process Plan: W Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4015	A-PRELIM								

100 Pick Kit 0.00



Packaging Memo 0.00

Packaging

110 Weld per dwg A/R Hardcoat S.S. Batch: 4112963 0.00



Large Fab Memo 0.00

Large Fab

120 QC5- Inspect part completeness to step on W/O 0.00



QC Memo 0.00

Quality Control

AX

20 09 11 13

14

2009.11.13

# Work Order ID 53682

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Item ID: D4015-041

Accept

Setup Start

Revision ID:

Item Name: Wearbar Weldment

Stop

Start Date: 11/12/09 Start Qty: 5.00

Required Date: 11/13/09 Req'd Qty: 5.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130

QC9- Inspect visual per QS1004- Fusion Welds

0.00

QC

Memo

0.00

Quality Control

140

Identify as per dwg & Stock Location:

0.00

Packaging

Memo

0.00

Packaging

150

QC21- Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control

POSITIVE RECALL

EFFECTIVE 11/12/09 AUTH U

RELEASED 11/12/09 DATE 11/12/09

See dwg  
for powder  
cost blisch  
recommendation  
7/09/11/13

# Picklist Print

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Page 1

Work Order ID: 53682



Parent Item: D4015-041



Parent Item Name: Wearbar Weldment

Start Date: 11/12/09

Required Date: 11/13/09

Comments: IPP RevA: New issue 09.11.03 DD verified by:EC  
remove waterjet 09.11.03 DD verified by:EC

IPP RevB:

Start Qty: 5.00

Required Qty: 5.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D4015-1		Manufactured	No			100	Each	0.0000	5.0000			



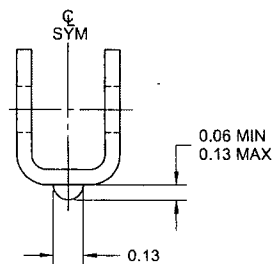
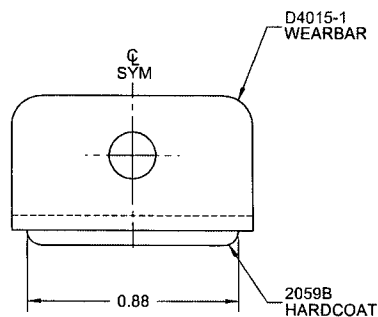
Wearbar

POSITIVE RECALL

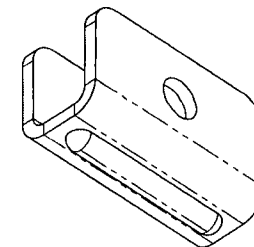
EFFECTIVE \_\_\_\_\_ AUTH \_\_\_\_\_  
RELEASED \_\_\_\_\_ DATE \_\_\_\_\_

u

ITEM	QTY	P/N	DESCRIPTION
1	1	D4015-041	WEARBAR
11	1	D4015-1	WEARBAR
21	A/R	2059B	HARDCOAT



*Handwritten:* 53682



**D4015-041 WEARBAR WELDMENT**

**PRELIMINARY ISSUE**

**NOTES:**

- 1) MATERIAL: SEE SHEET 2 FOR D4015-1
- 2) FINISH: POWDER COAT "GREY SANDTEX" (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.02 lbs
- 8) WELDING: PER DART QSI 004

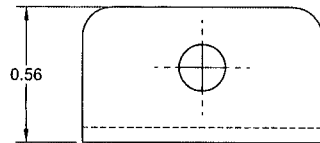
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P1	NEW ISSUE	MB	09.10.23
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	09.10.23		

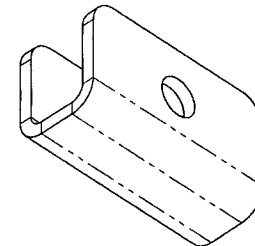
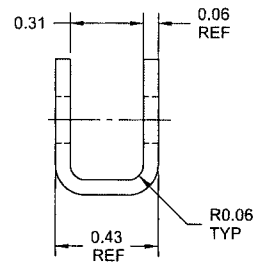
**DART AEROSPACE LTD**  
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D4015** REV. P1  
SHEET 1 OF 2  
TITLE **WEARBAR WELDMENT** SCALE NTS

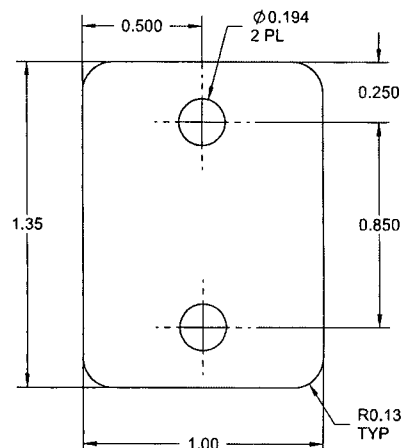
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**D4015-1 WEARBAR**  
MAKE FROM D4015-1



*Handwritten note: w/053682*



**D4015-1F WEARBAR FLAT PATTERN**

**NOTES:**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET ANNEALED 2B FINISH, 16 GAUGE (0.063 THICK)  
PER AMS 5513 (304) OR 5524 (316) OR ASTM A240 OR ASME SA240  
REF. DART SPEC. M304S16GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.02 lbs

**PRELIMINARY ISSUE**

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. <b>D4015</b>	REV. P1
MFG. APPR.		SHEET 2 OF 2	
APPROVED		TITLE	SCALE
DE APPR.		<b>WEARBAR</b>	NTS
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